

Date: Monday, 10/22/2007 10:34:19 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 35257	
Estimate Number : 12729	
P.O. Number : N/A	Part Number : D353539
This Issue : 10/22/2007 S.O. No. : N/A	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33629	Material : N/A
Written By : <u>HB 07-10-22</u>	Due Date : 10/31/2007 Qty: 26 Um: Each
Checked & Approved By : <u>HB 07-10-22</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM	
Est Rev:B As per Rev B 07-08-31 JLM	Verified By:EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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25.9636



Comment: Qty.: 0.9986 sf(s)/Unit Total : 15.9768 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 105871 HB 07-10-23

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

HB 07-10-23

(26)

2-Deburr if necessary

HB 07-10-23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-10-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

HB 07-10-23

counted

(26)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

Identify as D3535-41

Form Joggle on brake using Jig DT8158 as per Dwg D3535

HB 07-10-31

(26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 07/11/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 10:34:19 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 35257

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/10/31 (26) counters

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642

BR 07-01-02 (26)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 07-11-02 (26)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-16

BR 07-11-02 (26)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20111105 (26)

Job Completion



C20711105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	35257
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3535-39
<b>Inspection Dwg:</b> D3535 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	X			
32.775	+/-0.010	32.775	X			
29.275	+/-0.010	29.275	X			
25.775	+/-0.010	25.775	X			
23.250	+/-0.010	23.250	X			
19.750	+/-0.010	19.750	X			
17.750	+/-0.010	17.750	X			
14.250	+/-0.010	14.250	X			
9.500	+/-0.010	9.500	X			
4.750	+/-0.010	4.750	X			
2.000	+/-0.010	2.000	X			
5.00	+/-0.030	5.00	X			
9.00	+/-0.030	9.00	X			
28.00	+/-0.030	28.00	X			
Ø0.188	+0.005/-0.001	.189	X			
1.885	+/-0.010	1.885	X			
0.300	+/-0.010	.302	X			
0.300	+/-0.010	.304	X			
0.038	+/-0.010	.038	X			

<b>Measured by:</b> RB	<b>Audited by:</b> EJ	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07-10-23	<b>Date:</b> 07/10/23	<b>Date:</b>	N/A

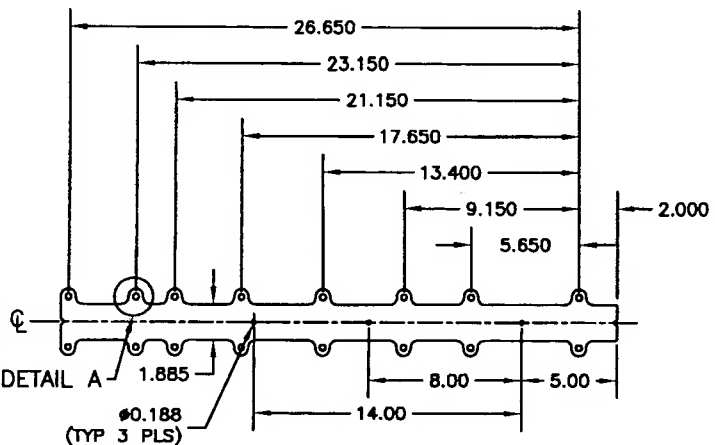
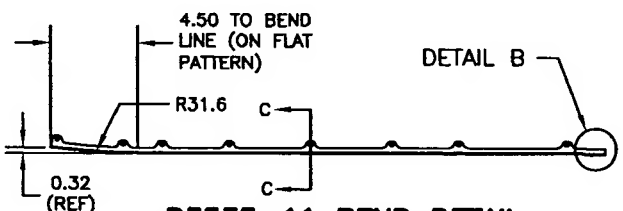
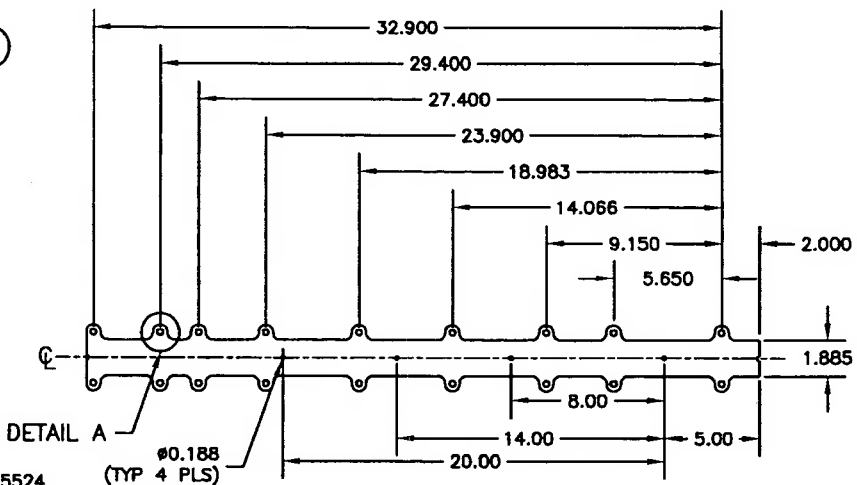
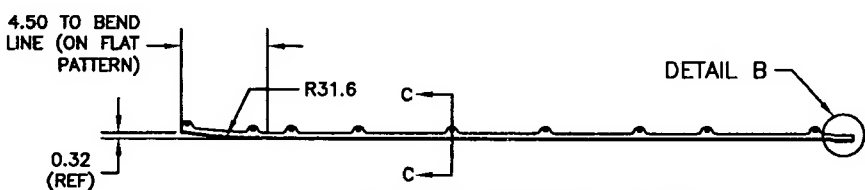
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	EJ

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07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
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		D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

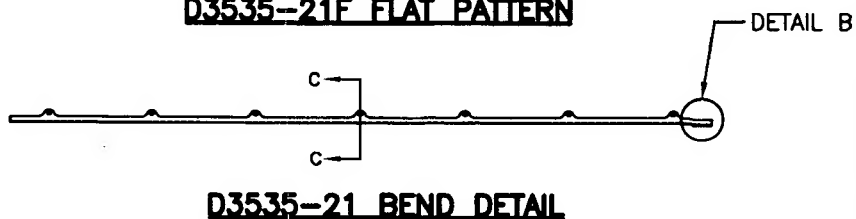
**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\bar{C}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10



- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER  
QSI 005 4.3
  - 3) PART IS SYMMETRICAL ABOUT C
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
  - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
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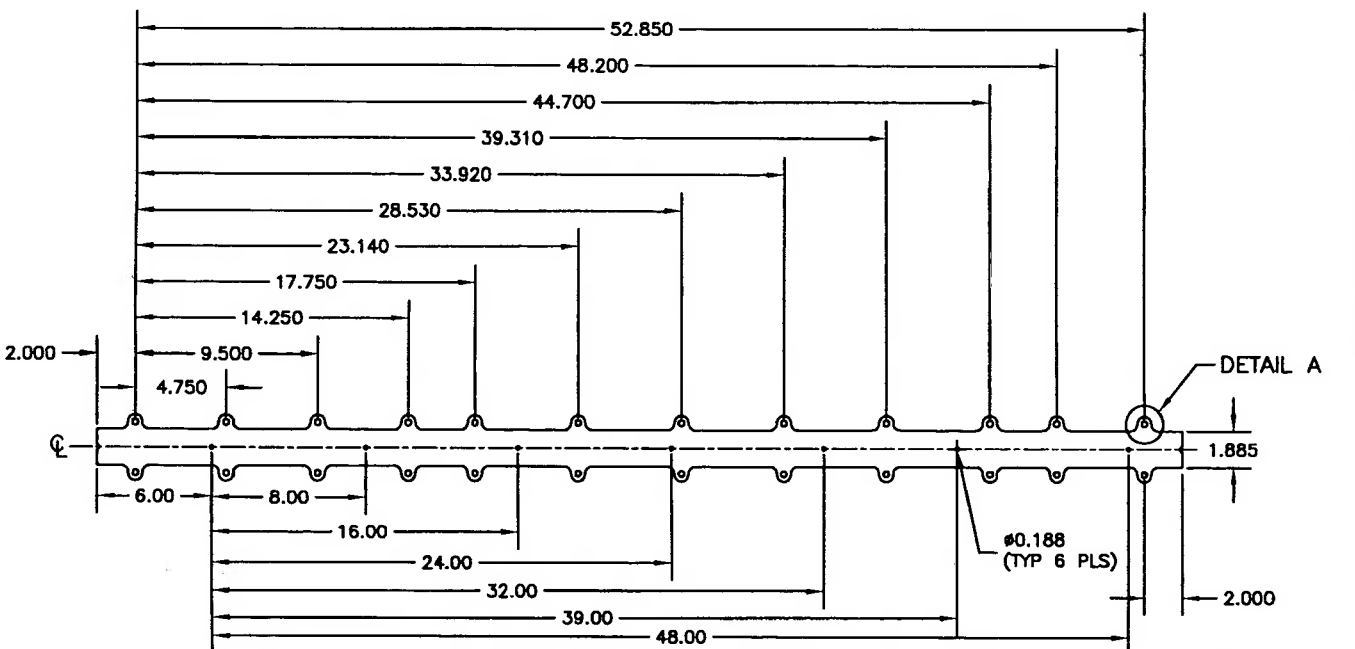
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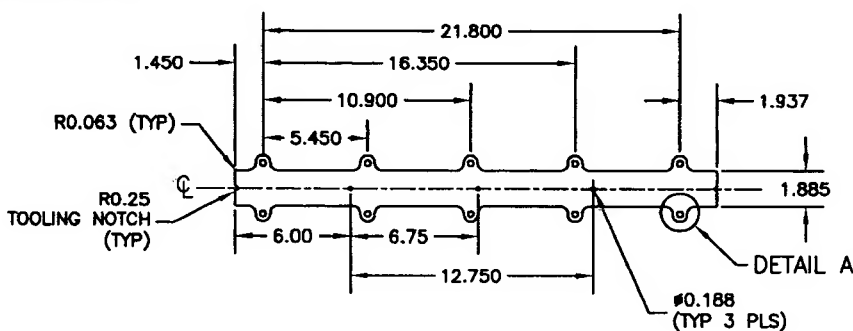
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		TITLE	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	



**D3535-23F FLAT PATTERN**

**D3535-23 BEND DETAIL**



**D3535-25F FLAT PATTERN**

**D3535-25 BEND DETAIL**

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**NOTES**

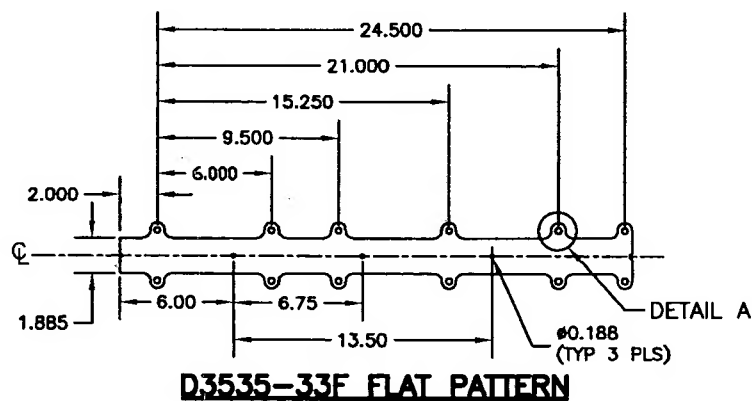
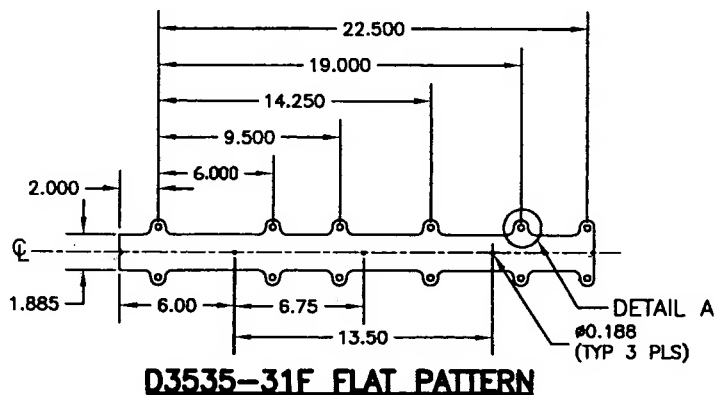
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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DATE	07.04.17	TITLE	WEARSHOE	REV. B SHEET 4 OF 7
		SCALE	1:10	



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**NOTES**

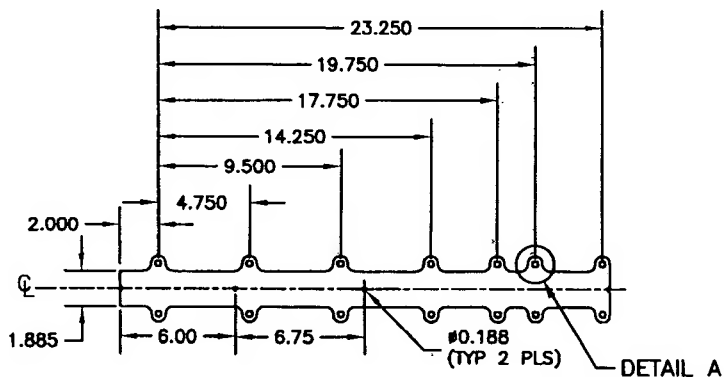
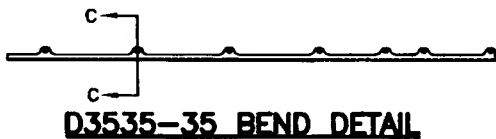
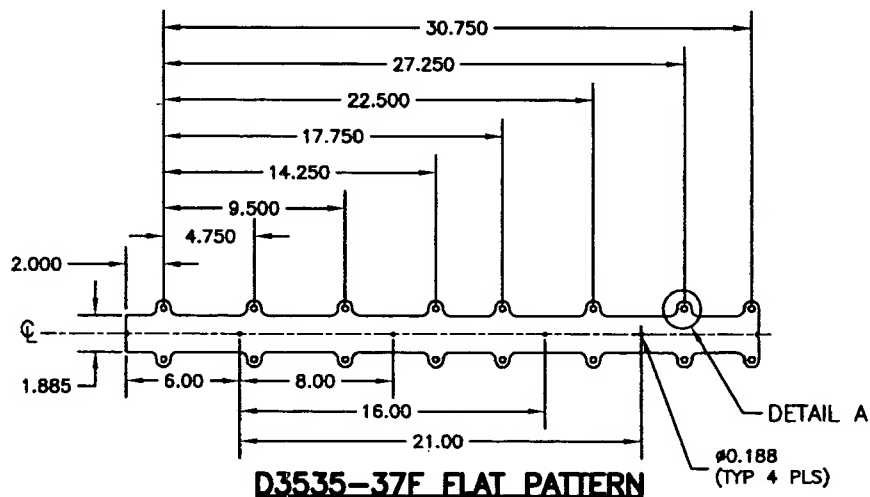
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		TITLE	WEARSHOE	SCALE	1:10

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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**NOTES**

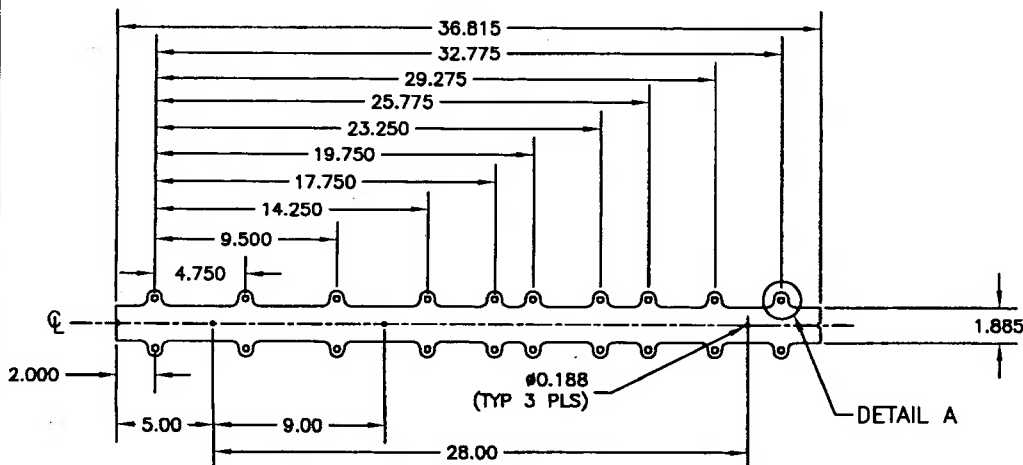
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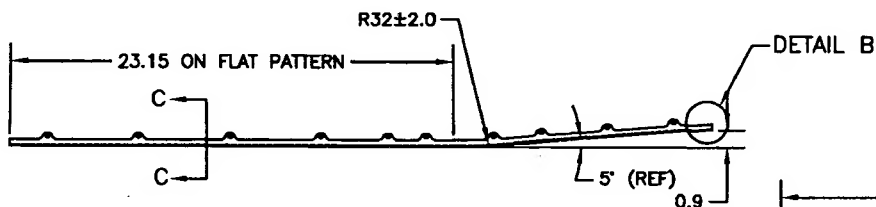
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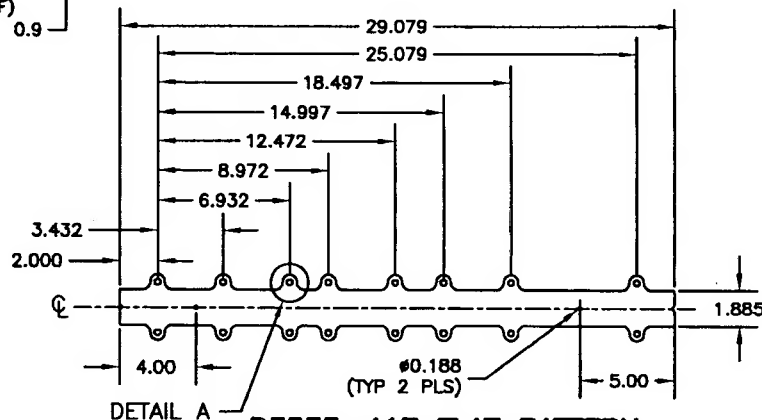
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		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



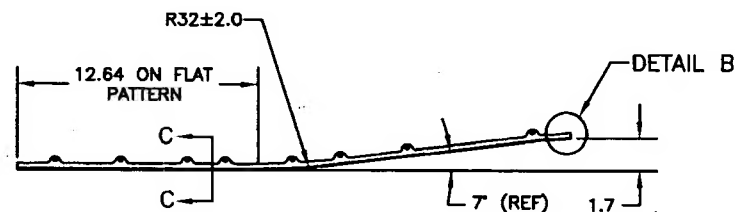
**D3535-39F FLAT PATTERN**



**D3535-39 BEND DETAIL**



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

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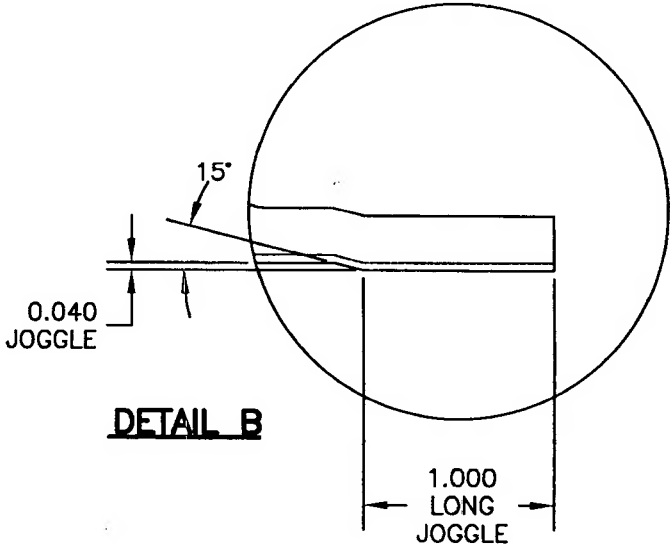
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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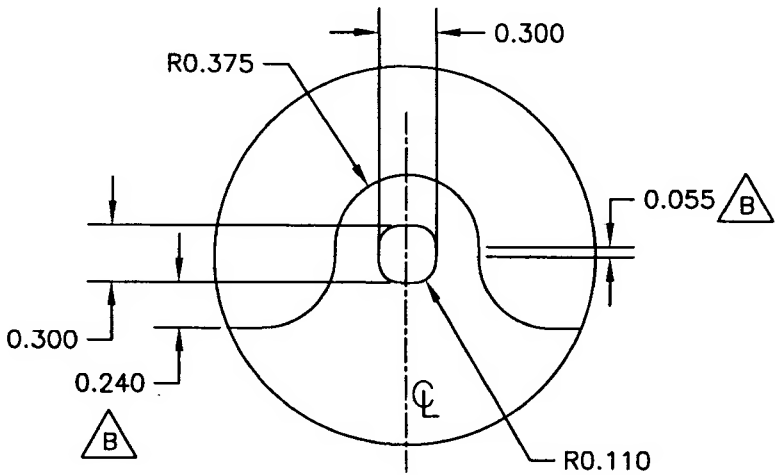


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DATE	07.04.17			SHEET 7 OF 7
		TITLE	WEARSHOE	SCALE 1:1

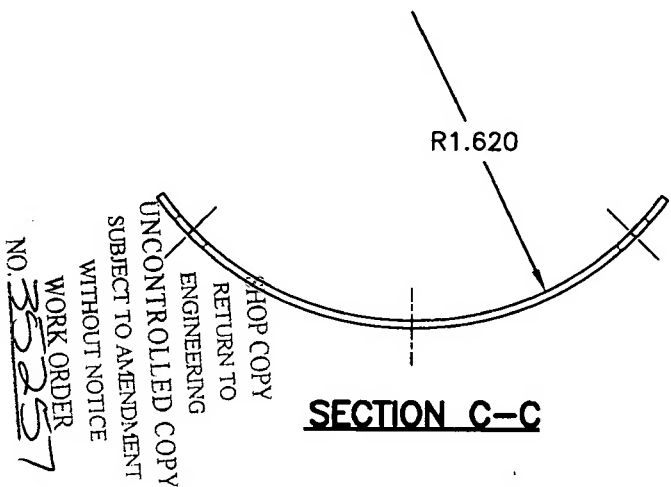
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**DETAIL B**



**DETAIL A**



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